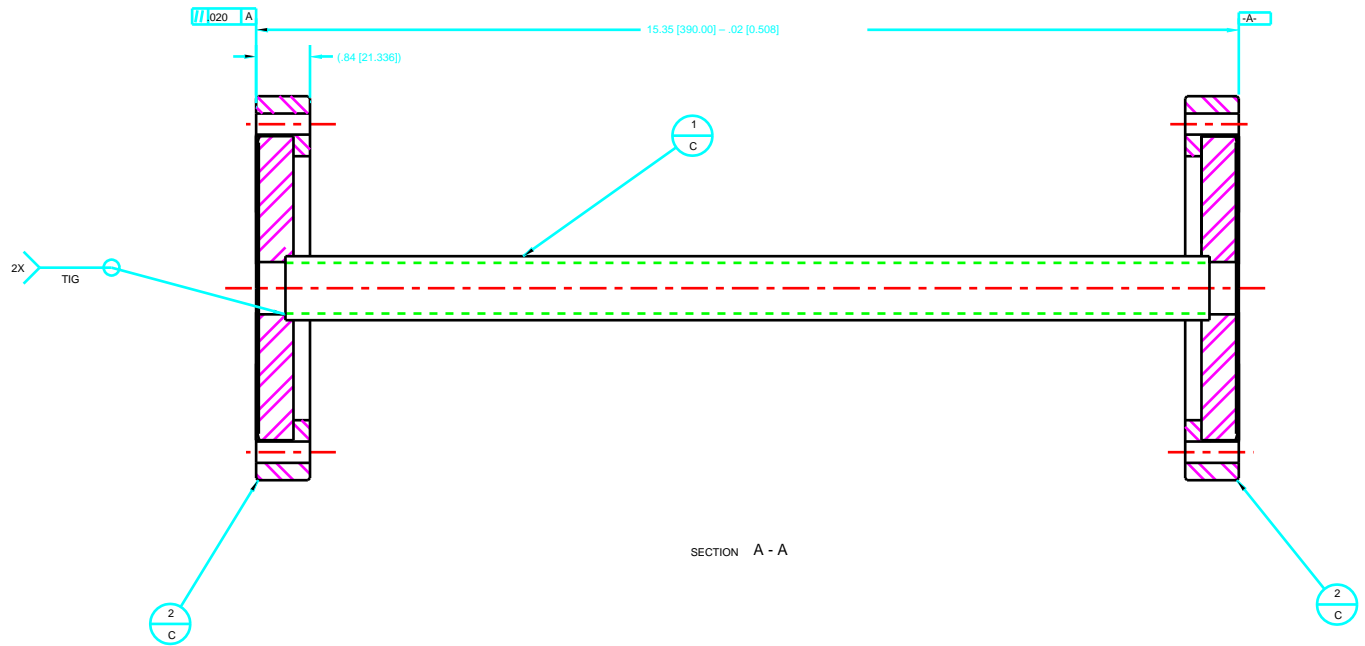
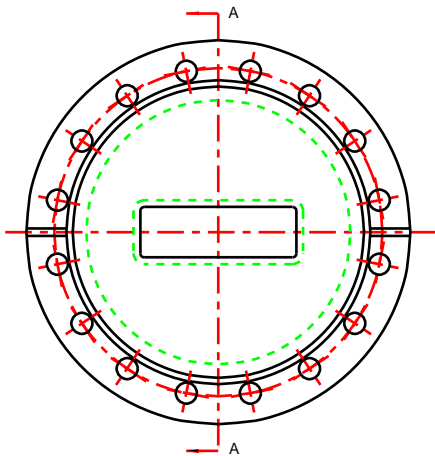


(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A08344
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NOTES:

1. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
DU PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.
- FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS FOR REF. ONLY

2 P4102010102-210102 K1 END FLANGE				2
1 P4102010102-210101 K1 RECTANGULAR CHAMBER				1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULARS X - .001 (25.4) - .005 XX - .001 (25.4) - .005 XXX - .001 (25.4) - .005		LOG NUMBER A08344	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DESIGNER MUSCIA		DATE 12/4/92	CHIEF DESIGN ENGINEER	TITLE ADVANCED PHOTON SOURCE K1 ID 1 ST COLLIMATOR VACUUM CHAMBER WELDMENT ASSEMBLY
DESIGNED BY		GP LEADER	PROJECT MGR.	
RESPONSIBLE ENGINEER		APPROVED/RELEASED		
MATERIAL SEE PARTS LIST		SCALE 1:1	SHEET 1 of 1	DWG NUMBER P4102010102-210100-00